

Work Order ID 67402

Friday, March 18, 2011 12:03:16 PM

Page 1

Item ID: D3042-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Clamp

Start Date: 3/21/2011 Start Qty: 30.00

Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: UMF Date: 11-03-18 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3042

Rev A

100

0.00



Waterjet

POUCHING

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: 2

304.063

2-Deburr if necessary

1311-3-21(40)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Ensure Material Release Note is attached

1311-3-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67402

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Page 2

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Start Date: 3/21/2011 Start Qty: 30.00

Required Date: 4/8/2011 Req'd Qty: 30.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8 u103/21

count
(40)

130



Brake NC

Brake NC

Form as per dwg
Small Fab

Memo

0.00

0.00

SB u103/23

(40)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 u103/23

count
(40)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 67402

Friday, March 18, 2011 12:03:17 PM



Page 3

Item ID: D3042-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 3/21/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 457

0.00



Packaging

Memo

0.00

Packaging

over 100

11/3/23

(400)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/23

C211/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, March 18, 2011 12:03:12 PM

Page 1

Work Order ID: 67402



Parent Item: D3042-1



Parent Item Name: Clamp

Start Date: 3/21/2011


Required Date: 4/8/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: C 01.11.08 Revised Step 5 SM
11.03.17 now made in house DD verf:EC

IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	11.5000	0.03	0.947368			

304/316 Sheet .063



1317-3-21

Location

Loc Qty

Loc Code

MAT020

11.5

116623

11.5

116623

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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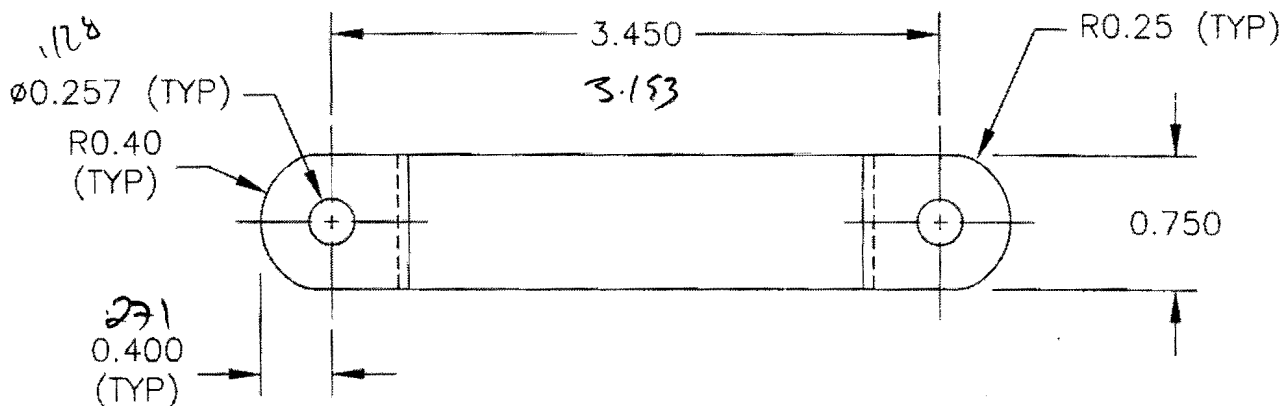
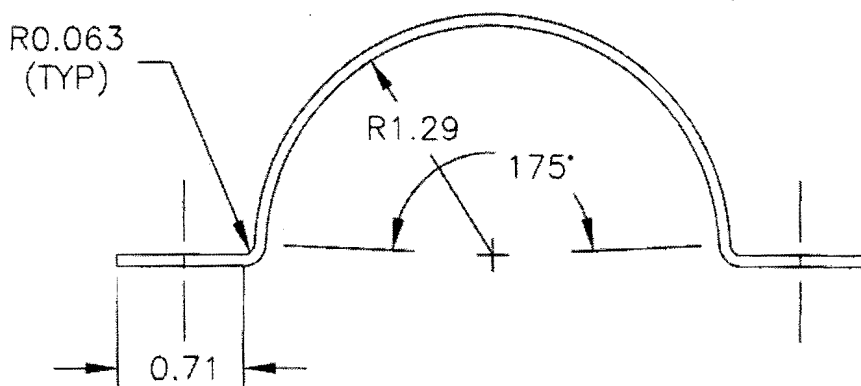
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3042	REV. A SHEET 1 OF 1
DATE 01.06.29		TITLE CLAMP	SCALE 1:1
A	01.06.29	NEW ISSUE	

RELEASED
01.07.09 [Signature]

#67402



D3042-1

- 1) MATERIAL: AISI 304/316 SS ANNEALED PER AMS 5513/5524
0.063 THICK
- 2) FLAT LENGTH: 5.713 END-TO-END
4.913 HOLE-TO-HOLE
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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